

Date: Tuesday, 3/11/2008 1:17:12 PM  
 User: Kim Johnston

## Process Sheet

16

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : DUAL HIGH BACK SEAT
Job Number : 37809	
Estimate Number : 12271	
P.O. Number :	Part Number : D350689041
This Issue : 3/11/2008 S.O. No. :	Drawing Number : IIN-D350-689 PG9
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : LARGE FAB ASSY	Drawing Revision : A
Previous Run : 36124	Material :
Written By :	Due Date : 4/15/2008 Qty: 1 Um: Each
Checked & Approved By : <u>JB 08 03 11</u>	
Comment : Est Rev: H Removed Sub-Parts 06-02-09 JLM	
Est Rev: I As per NCR 070 06-09-06 JLM	

## Additional Product

Job Number: 

Seq. # Machine Or Operation: Description:

1.0 D30231 Back Panel



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3023-1 Back Panel B 37877

JB 08/06/11

①

2.0 D3017041 Back Frame Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3017-041 Back Assembly B 37871

JB 08/06/11

①

3.0 MS20600AD4W2 Rivet



Comment: Qty.: 40.0000 Each(s)/Unit Total: 40.0000 Each(s)

Pick:

Qty Part Number Description Batch

40 ms20600ad4w2 Rivet M106513

JB 08/06/11

①

4.0 MS20600AD4W3 Cherry Rivets



Comment: Qty.: 6.0000 Each(s)/Unit Total: 6.0000 Each(s)

Cherry Rivets

Batch: M18071

JB 08/06/11

①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Drawing Name: DUAL HIGH BACK SEAT

Job Number: 37809

Part Number: D350689041

Job Number:



Seq. #:

Machine Or Operation:

Description:

5.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Assemble as per IIN 350-689-041

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

9.0

D30241

Spacer



Comment: Qty.: 3.0000 Each(s)/Unit Total: 3.0000 Each(s)

Pick:

Qty Part Number Description Batch

3 D3024-1 Spacer B33368

10.0

D30281

Stud



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 D3028-1 Stud B29630 (14)

11.0

D30291

Spring



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3029-1 Spring B33370

30 min  
11/06/2008  
S.008 16.03  
#1 318.7 F  
#2 337804 F  
#3 335068904 F

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Drawing Name: DUAL HIGH BACK SEAT

Job Number: 37809

Part Number: D350689041

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

D30301

Lock



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3030-1 Lock

B34311

EB08/06/12

13.0

D30311

Loop



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3031-1 Loop

B33474

EB08/06/12

14.0

AN312A

Bolt



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty Part Number Description Batch

3 AN3-12A Bolt

M106605

EB08/06/12

15.0

AN960JD10L

Washer



Comment: Qty.: 23.0000 Each(s)/Unit Total : 23.0000 Each(s)

Pick:

Qty Part Number Description Batch

23 AN960JD10L Washer

M104885

EB08/06/12

16.0

MS21042L3

Nut



Comment: Qty.: 23.0000 Each(s)/Unit Total : 23.0000 Each(s)

Pick:

Qty Part Number Description Batch

23 MS21042L3 Nut (or -3)

M107644

EB08/06/12

17.0

MS24693S272

Screw



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 MS24693-S272 Screw

M104746

EB08/06/12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number: 37809

Part Number: D350689041

Job Number:



Seq. #:

Machine Or Operation:

Description :

18.0

MS27039117

Screw



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 MS27039-1-17 Screw

1111540

EB08/06/12

19.0

MS27039119

Screw



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty Part Number Description Batch

12 MS27039-1-19 Screw

1100089

EB08/06/12

Seq. 20.0

D30221

Seat Pan



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description

1 D3022-1

Seat Pan

Batch

B 37875

EB08/06/12

21.0

D3021041

Tube Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description

1 D3021-041

Tube Assembly

Batch

B 37873

EB08/06/12

22.0

D3016041

Seat Frame Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description

1 D3016-041

Frame Assembly

Batch

B 39599

EB08/06/12

23.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Assemble as per Dwg IIN-D350-689

EB08/06/12 @

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number: 37809

Part Number: D350689041

Job Number:



Seq. #:

Machine Or Operation:

Description :

24.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/06/12 (2)

25.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

PPP 39101

08/06/12 (1)

26.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/06/12 (2)

Job Completion



MF 08-06-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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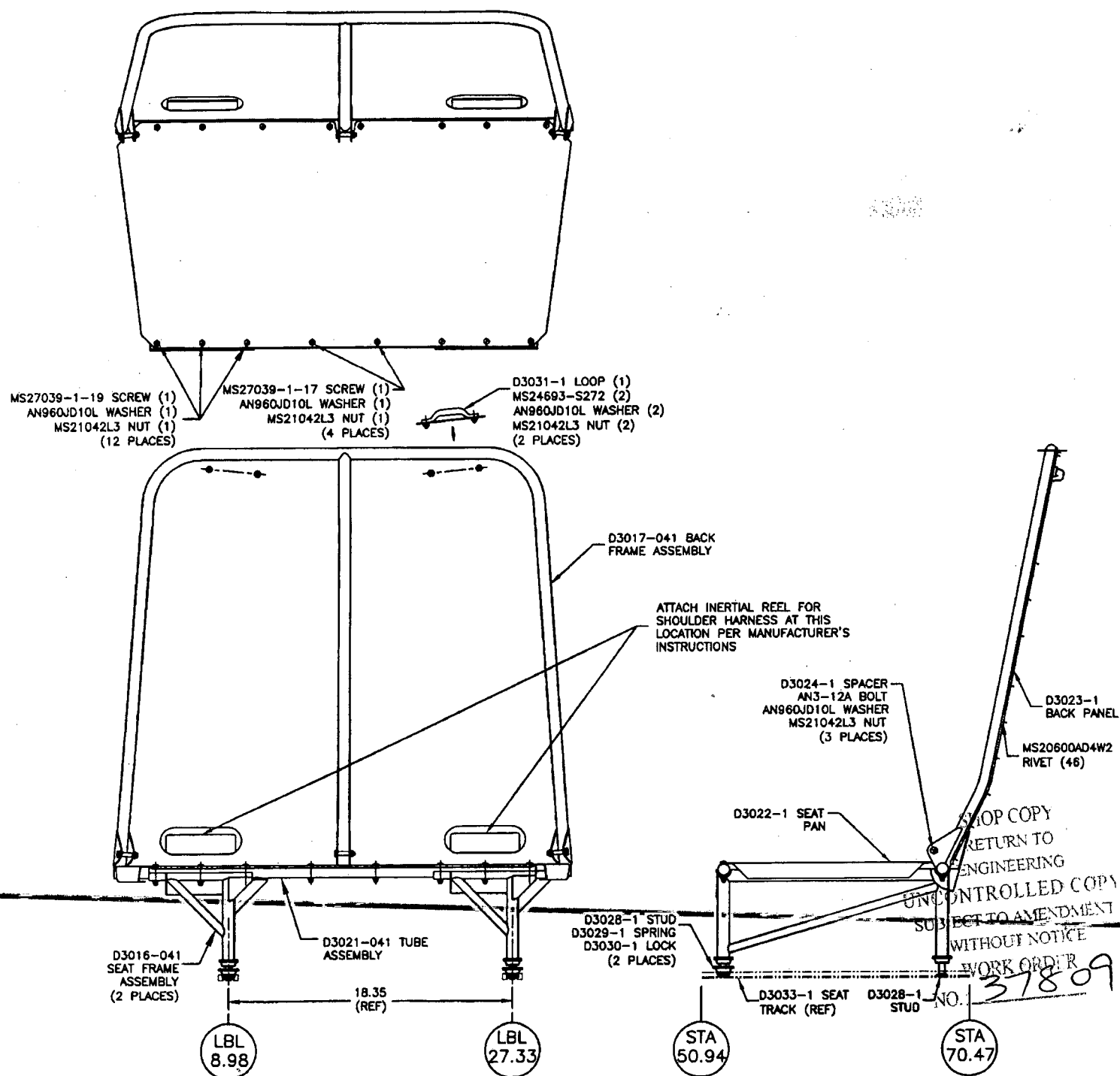


FIGURE 6: Installation of D350-689-041 Dual High Back Seat Assembly

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Revision: A

Date: 01.05.30